



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4504-1

Job Sheet 192037



Part No: D4504-1

Job Qty: 1 pcs

Part Name: Half Height Bubble Window, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/14/19

Job Tracking No:

Due Date: 4/25/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: D4504 REV.A IPP Rev. A New Issue 12/02/16 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs	4/25/19		0.00	0.00	Purchasing - 1		MAY 28 2019
							Purchasing - 2		
							Purchasing - 3		
110	Packaging 2-1 - Receive - B4B	1 pcs	4/25/19		0.00	0.00	Packaging 2 - 1 - B4B		MAY 28 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		
							Packaging 2 - 28 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S184506



Part: D4504-1

Job No: 192037

Serial No/Batch: S184506

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/28/19

Plex 3/14/19 1:28 PM dart.Lussier.Patrick

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120 QC 6	1 pcs	4/25/19	0.00 0.00		QC 6 - 42	
					QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
130 Packaging 3-1 - Stock - B4B	1 pcs	4/25/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - SA	1 pcs	4/25/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 100 - ISSUE P/O: MANUFACTURE AS PER DWG D4504 C OF C IS REQUIRED ***EXTREME CARE MUST BE TAKING WHEN PACKAGING AND SHIPPING THIS PRODUCT.***

110 - ***EXTREME CARE MUST BE TAKING WHEN PACKAGING AND SHIPPING THIS PRODUCT.***

130 - ***EXTREME CARE MUST BE TAKING WHEN PACKAGING AND SHIPPING THIS PRODUCT.***

042894 x1 Rhs March 14, 2019

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D4504-1P	Half Height Bubble Window, LH	1 Ea (1 ea)	100-Purchasing	5184505
MACRLICS.236	Plexiglass G 0.236"	13.7500 sf (13.75 ea)	100-Purchasing	5152010
		178sf		
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D4504-1P	1	0	0
	MACRLICS.236	14	288	0
Part Specifications				
Specifications could not be found.				

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO042894**



Supplier: PLA002-VC
Plas-Tech
115 Applewood Crescent
Concord
ON
L4K 5C1 Canada
Phone: 416-736-0004
Fax: 416-736-0010

PO No: PO042894
PO Date: 3/14/19
Due Date: 5/23/19

Purchase Order
Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Revision

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	192036	D4504-1P			Half Height Bubble Window, LH : Various STC's	Firmed	-	5/27/19	1 Ea	0 Ea	1 Ea	\$600.00/Ea	\$600.00
						<i>XI</i>		<i>MAY 27 2019</i>				<i>DP</i>	
2	192037	D4504-1P			Half Height Bubble Window, LH : Various STC's	Firmed	-	6/10/19	1 Ea	0 Ea	1 Ea	\$395.00/Ea	\$395.00
						<i>IX</i>		<i>MAY 28 2019</i>					

Grand Total: \$995.00

Order Notes

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

PL

Plex 5/27/19 2:59 PM dart.Lussier.Patrick

PLAS-TECH
Think Plastics.

115 Applewood Crescent
Concord, ON, L4K 5C1
PLASTECHONLINE.COM

P- 416 736 0004
F- 416 736 0010

Shipment Number:

35833

Shipment Date:

05/23/2019

BOL Number:

C1887

Customer Key:

MIKE AUBE

Salesperson:

Page Number:

1 of 1

B DART AEROSPACE LTD.
I 1270 ABERDEEN STREET
L HAWKESBURY ON K6A 1K7
L CA
T Attn: DALE BATES
O Buyer Contact: PATRICK LUSSIER

S DART AEROSPACE
H 1270 ABERDEEN STREET
I HAWKESBURY ON K6A 1K7
P CA
T Attn: PATRICK LUSSIER
O

RECEIVED

MAY 27 2019

DART AEROSPACE LTD.

Purchase Order

42894

Sales Order

SO-028592

Incoterms

EX WORKS

Payment Method

COL

Carrier Account #

CU103666

Ship Via

JOURNEY FREIGHT -

Tracking Number

Item Number
Revision

Description

Quantity
Shipped

UOM

D4504-1P - Rev.: A

HALF HEIGHT BUBBLE WINDOW

1

EA

AS PER DWG D4504 REV A

D4504-1P - Rev.: A

HALF HEIGHT BUBBLE WINDOW

1

EA

AS PER DWG D4504 REV A

Number of Containers

Gross Weight

Shipped By

Certificate Of Conformance



Customer: DART AEROSPACE LTD P.O. # 42894 SO # 028592

Part #	<u>D4504-1P</u>	Qty.	<u>1</u>	Batch #	<u>-001</u>
Description	<u>HALF HEIGHT BUBBLE WINDOW</u>	Material usage	<u>120 SQ.FT.</u>	Lot#	<u>DART0118 S152010</u>
Part #	<u>D4504-1P</u>	Qty.	<u>1</u>	Batch #	<u>-002</u>
Description	<u>HALF HEIGHT BUBBLE WINDOW</u>	Material usage	<u>120 SQ.FT.</u>	Lot#	<u>DART0118 S152010</u>
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	

Note: All parts are not identified as meeting QSI044.

By: AS
(Approved QA Signatory)

Date: MAY 24, 2019 COFC # 117

Page: 1 of 1

Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

Email: info@plasteconline.com, Web: www.plasteconline.com

Certificate Of Conformance



Customer: DART AEROSPACE LTD

P.O. #

42894 ✓

SO #

028592

Part #	D4504-1P ✓	Qty.	1 ✓	Batch #	-001
Description	HALF HEIGHT BUBBLE WINDOW	Material usage	120 SQ.FT.	Lot#	DART0118 S152010
Part #	D4504-1P ✓	Qty.	1 ✓	Batch #	-002
Description	HALF HEIGHT BUBBLE WINDOW	Material usage	120 SQ.FT.	Lot#	DART0118 S152010
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	
Part #		Qty.		Batch #	
Description		Material usage		Lot#	

Note: All parts are not identified as meeting QSI044.

By:

(Approved QA Signatory)

Date:

MAY 24, 2019

C OF C #

117

Page: 1 of 1

Plas-Tech Inc. 115 Applewood Cres. Concord, Ontario L4K 5C1 Tel: (416) 736-0004 Fax: (416) 736-0010

Email: info@plasteconline.com, Web: www.plasteconline.com

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

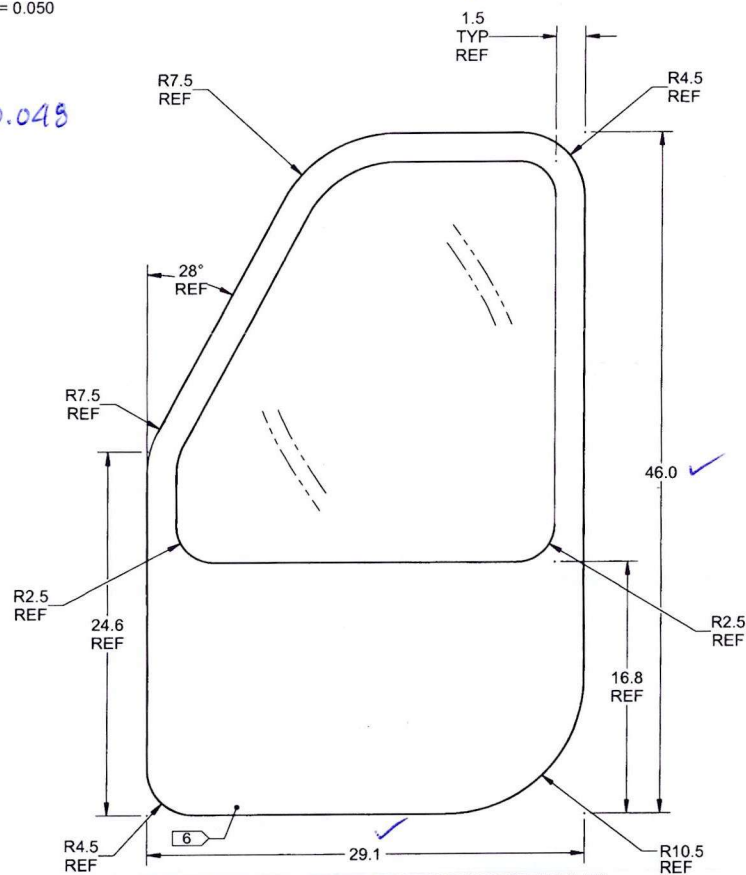
Route update only ☐

Job: <u>192037/192036</u> Part No. <u>D4504-1</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☒ Quality ☐					
Date : <u>MAY 28 2019</u>		Sequence #: <u>120 QCG</u>		QTY Affected : <u>1 + 1 (2PCS)</u>		MRB (QSI042) <u>INSP 12 4/14/20</u>			
Description Work Order Deviation <u>- DRAWING SPECIFIES MIN. THK. OF 0.050" FOR OUTER 7.2".</u> <u>- ACTUAL FOR OUTER 5" IS 0.031" - 0.049"</u> DAS 68 9-89				Disposition <u>Approx 14" sq. area under tolerance by up to 0.015". Rejected.</u>				Completed By Lead hand / Supervisor QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread							
		Other/Details:							

0.102
 3.0
 MIN THICKNESS = 0.070
 5.0
 MIN THICKNESS = 0.090
 0.236
 REF

MAX DEPTH = 15.0 ± 0.5 *15 3/16*
 7.2
 MIN THICKNESS = 0.050

0.031-0.0048



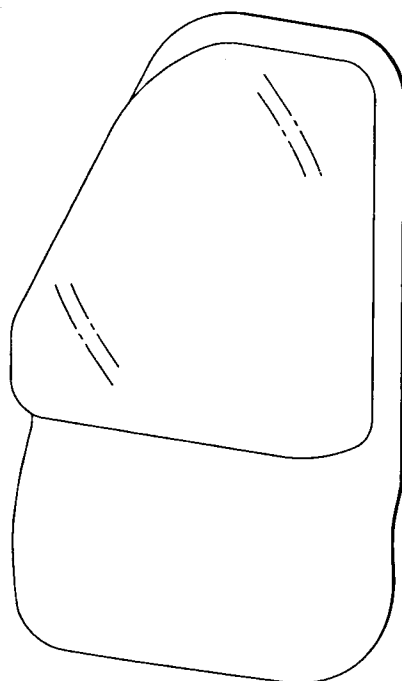
D4504-1 HALF HEIGHT BUBBLE WINDOW (LH)

RELEASED
 2012-03-08
WJ

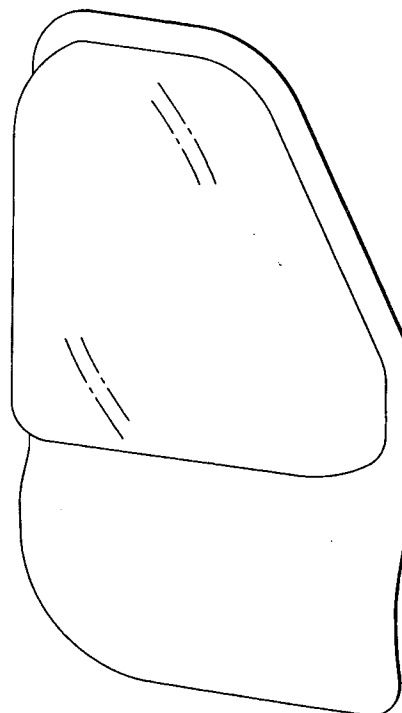
NOTES:

- 1) MATERIAL: PLEXIGLASS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C
 OR POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425,
 0.236 THICK (REF. DART SPEC. M-ACRYLIC-S.236)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: ENGRAVE P/N "D4504-1" & B/N "BXXXXX" ON THE INSIDE SURFACE
 WITHIN 0.50" OF BOTTOM EDGE. USE 0.125" LETTERS TO MAX. DEPTH OF 0.005"
 PER QSI 044 6.4 WITH VIBRATING STYLUS
- 7) WEIGHT: 11.0 lbs
- 8) THERMOFORM PER DART QSI 022 USING DT8992 & DT9795

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4504	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 3	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	HALF HEIGHT BUBBLE WINDOW	NTS
DATE	12.03.01	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



D4504-1 HALF HEIGHT BUBBLE WINDOW (LH)



D4504-2 HALF HEIGHT BUBBLE WINDOW (RH)

RELEASED
2012-03-08

A		NEW ISSUE		AP	12.03.01
REV.		DESCRIPTION		BY	DATE
DESIGN	AP	DART AEROSPACE LTD			
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA			
CHECKED	AP	DRAWING NO.		REV. A	
MFG. APPR.	AP	D4504		SHEET 1 OF 3	
APPROVED	AP	TITLE		SCALE	
DE APPR.	AP	HALF HEIGHT BUBBLE WINDOW		NTS	
DATE	12.03.01	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			